

Work Order ID 80691

80691

Page 1

February-27-12 2:51:07 PM

Item ID: D205-634-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 27/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/27 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580-041	(DEO) Rev.E								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041		CHG005						
110		0.00							
110	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio 16								
	2-Cut tubes as per Dwg. D2580								
	3- scribe batch# in aft end of tube								

MLJ 12/03/23

8/2/03/27

PR 12/03/05

80691.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for welding as per QSI 004



Handwritten signature and initials

12-03-12

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

1 0

BE 12/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							

140

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004
A/R Aluminum Rod *mid 2012*

2-Grind welds on step as per Dwg D2580

3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.

4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

QC

Memo

0.00

Quality Control

Sick 1/13

[Signature]

14-03-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC5- Inspect part completeness to step on W/O 0.00

160

QC

Memo

Quality Control

0.00

8/26/13

170 Pressure Wash per QSI005 4.3 0.00

170

HandFinish

Memo

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

0.00

IXQM 12/03/13

180 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

180

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10h10
320°F
10h40

0.00

M120 222

1 & 12/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									

1 BL 123.15.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N9000040100

Setup Start *NS1*

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Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 27/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 119999
Sikaflex expire date: 12-8.

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 119999
Sikaflex expire date: 12-8.

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 120125

1 BR 12-3-15

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC5- Inspect part completeness to step on W/O

0.00

210

QC

Memo

0.00

5/2/12

Quality Control

Inspect Aft.Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00

220

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

11/4/12

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

12/3/12

112-032

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 80691

80691

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 27/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS
 PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1		Manufactured	No			140	Each	458.0000	20	20			
D4202-1									**	(20)		12-03-12	
Spacer													

Location	Loc Qty	Loc Code
LG	5	
77727	5	
LG002	453	
78806	453	

D2580-1		Manufactured	No			110	Each	10.0000	1	1			
D2580-1									**	(1)		12-03-05	
205 Skidtube bent detail													

Location	Loc Qty	Loc Code
LG	10	
76570	2	
77679	2	
79854	2	
79855	2	
80124	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 80691

80691

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 27/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2576-3 Manufactured No

140 Each 57.0000 1 1

D2576-3

**

Step (maching detail)

BR 12/03/12

Location	Loc Qty	Loc Code
LG	57	
70883	7	
74136	50	

D2855 Manufactured No

200 Each 60.0000 1 1

D2855

**

Cap

BR 12-3-15

Location	Loc Qty	Loc Code
FP002	60	
65519	2	
73347	30	
75074	28	

AN3-5A Purchased No

200 Each 1,195.000 2 2

AN3-5A

**

Bolt

BR 12-3-15

Location	Loc Qty	Loc Code
ST350	1195	
115371	46	
117423	204	
118626	245	
119355	200	
120187	500	

AN960JD10L * NAS1149D0332J Purchased No

200 Each 0.0000 2 2

*AN960JD10I *

**

Washer

120644

2 BR 12-3-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 27/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

2,472.000

50

50

AI S7-1032-130

**

BR 12-3-15

Insert

Location

Loc Qty

Loc Code

ST280

328

117717

27

118966

22

119775

279

ST281

71

119794

71

ST282

2073

119530

73

120181 ✓

2000

50

AN3C4A

Purchased

No

200

Each

3,657.000

50

50

AN3C4A

**

BR 12-3-15.

BOLT

Location

Loc Qty

Loc Code

ST350

3657

117688

5

118112

16

119749

10

120187

2000

120423

10

120521

924

120769

515

120799

177

50

AN960C10L

*NAS1149C0332/ R

Purchased

No

200

Each

0.0000

50

50

*AN960C10I *

**

50. BR 12-3-15.

washer

120648.

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 27/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3566-13
D3566-13
Gasket

Manufactured No

200 Each

42.0000

1 1

**

BR 12-3-15

Location

Loc Qty

Loc Code

FP002

42

76947 ✓

42

1

D3566-5
D3566-5
Gasket

Manufactured No

200 Each

17.0000

1 1

**

BR 12-3-15

Location

Loc Qty

Loc Code

FP002

17

76945 ✓

17

1

D3566-1
D3566-1
Gasket

Manufactured No

200 Each

24.0000

2 2

**

BR 12-3-15

Location

Loc Qty

Loc Code

FP002

24

68924

2

78808

22

2

D3564-11
D3564-11
Wearshoe

Manufactured No

200 Each

30.0000

1 1

**

BR 12-3-15

Location

Loc Qty

Loc Code

FP

1

76268

1

FP001

29

77056

17

78871 ✓

12

1

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Parent Item Name: Replacement Skidtube

Start Date: 27/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-13
D3564-13
Wearshoe

Manufactured No

200 Each

27.0000

1 1

**

BR 12-3-15.

Location	Loc Qty	Loc Code
FP001	16	
71594	1	
77610	15	
FP002	11	
76946 ✓	11	1

D3564-9
D3564-9
Wearshoe

Manufactured No

200 Each

14.0000

1 1

**

BR 12-3-15.

Location	Loc Qty	Loc Code
FP001 76950	14	L
67590	4	
69943	1	
78872	9	

D3564-5
D3564-5
Wearshoe

Manufactured No

200 Each

26.0000

1 1

**

BR 12-3-15.

Location	Loc Qty	Loc Code
FG	2	
34806	2	
FP001	24	
73330 ✓	1	
76944 ✓	11	1
77609	12	

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 27/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

3,006.000

16

16

D2594-3

**

O-Ring, 205 Skidtube

BL 12.3-15.

Location

Loc Qty

Loc Code

FP001

3006

65518

41

79496

1000

79573

50

79755 ✓

1915

16

D2594-1

Manufactured No

200

Each

583.0000

16

16

D2594-1

**

Plug, 205 Skidtube

BL 12.3-15.

Location

Loc Qty

Loc Code

FP001

322

73401

30

74442

34

74869 ✓

152

77035

106

16

FP-A

261

73401

0

78590

261

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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LIST OF MATERIALS

ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
27			8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DEO ATTACHED

RELEASED
2011-08-29
WJ

UNCONTROLLED

SUBMITTAL REQUIRED

NO. 80691 - MLJ
12/02/27

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	40	DRAWING NO.	REV. E
MFG. APPR.	18	D2580	SHEET 1 OF 8
APPROVED	40	TITLE	SCALE
DE APPR.	40	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

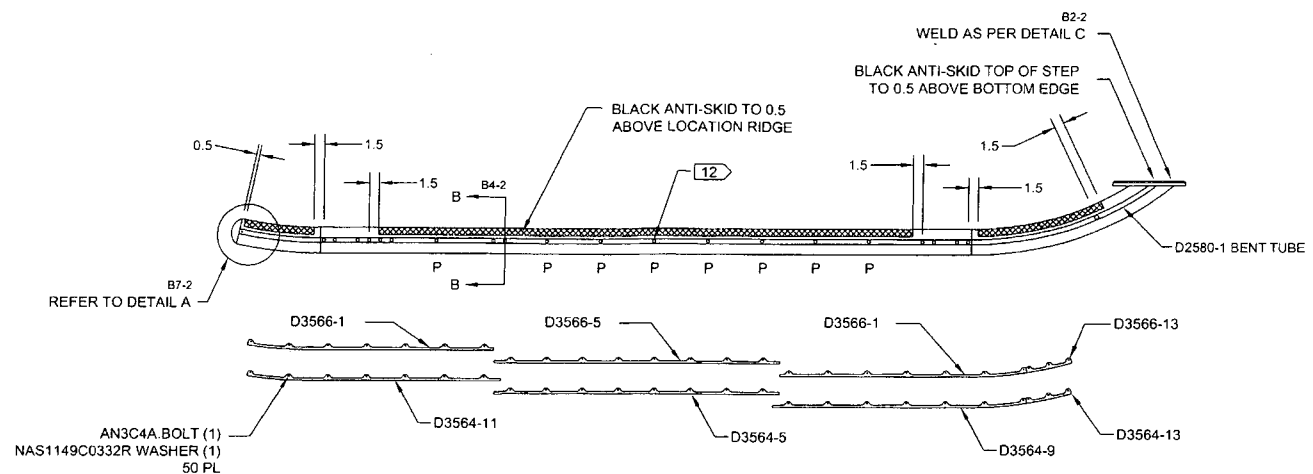
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

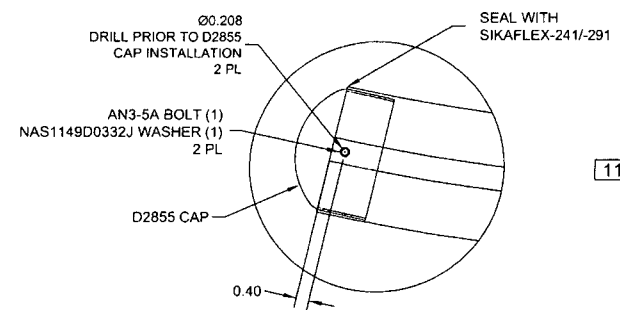
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20691

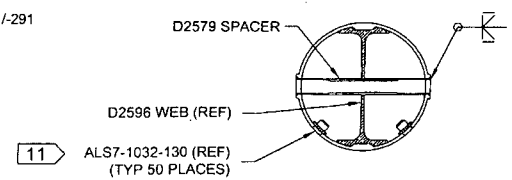


D2580-041 ASSEMBLY DETAIL

DETAIL A
C7-2
SCALE 5X

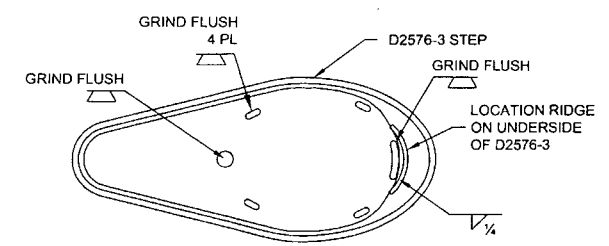


SECTION B-B
D5-2
SCALE 5X



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL C
D3-2
SCALE 5X



DESIGN	4	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 2 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

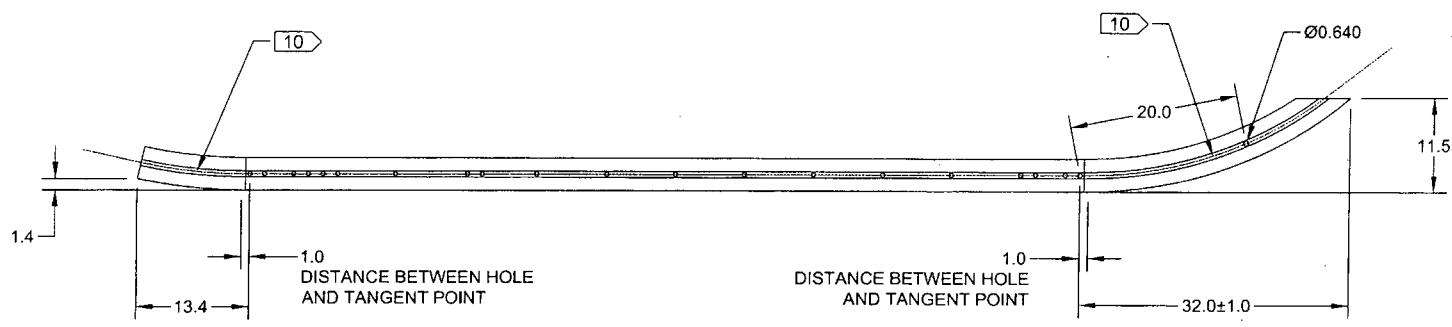
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80691



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

DEO ATTACHED

RELEASED
2011-08-28
JW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 3 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
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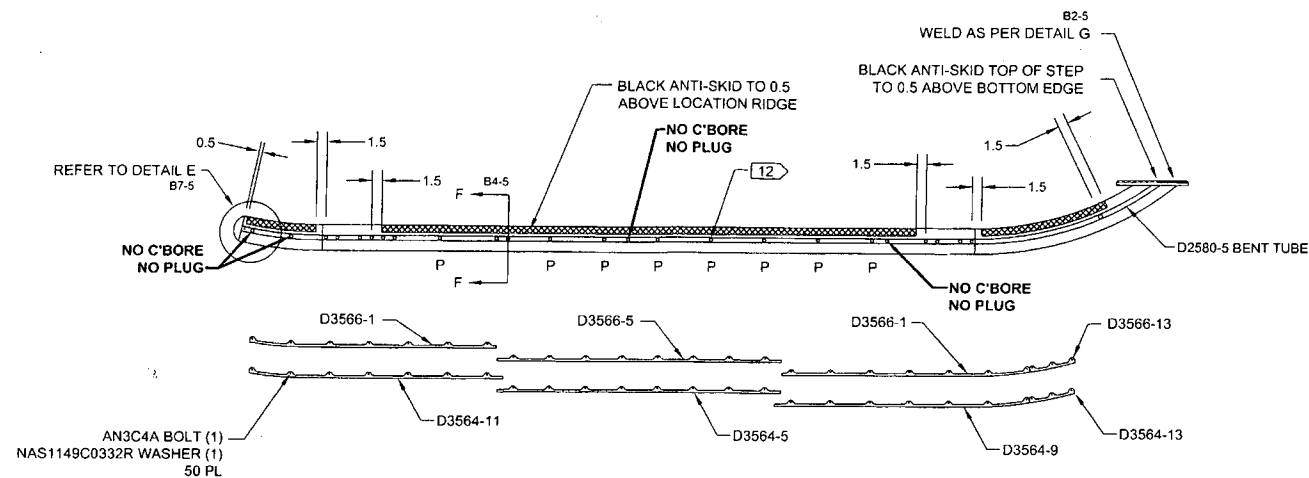
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

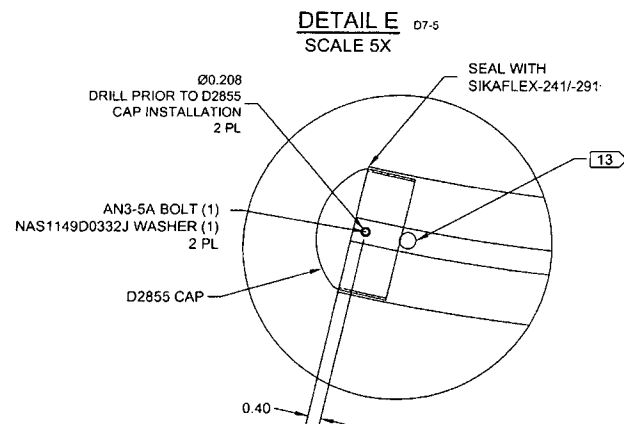
NOTE: Date & initial all entries



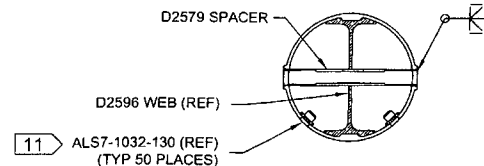
D2580-045 ASSEMBLY DETAIL

DEO ATTACHED
RELEASED
2011-08-29
mp

2011-08-2
W

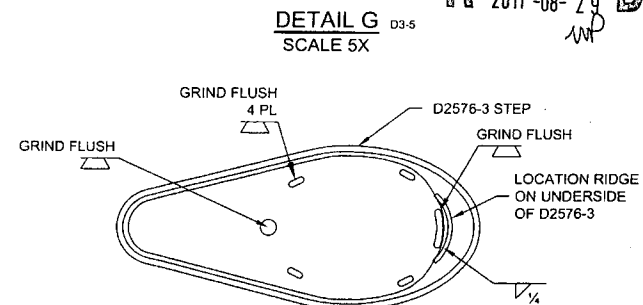


SECTION F-F D5-5
SCALE 5X



**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

- 1. CHAMFER HOLE 0.050 X 45°**
- 2. INSERT D2579 SPACER (24 PLACES)**
- 3. WELD INTO PLACE AND GRIND FLUSH**
- 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP**



DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 TITLE 205 SKIDTUBE ASSEMBLY COPYRIGHT © 1996 BY DART AEROSPACE LTD. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	REV. E
DRAWN	RF		SHEET 4 OF 6
CHECKED	10		
MFG. APPR.	10		
APPROVED	10		SCALE
DE APPR.	10		NTS
DATE 11.06.21			

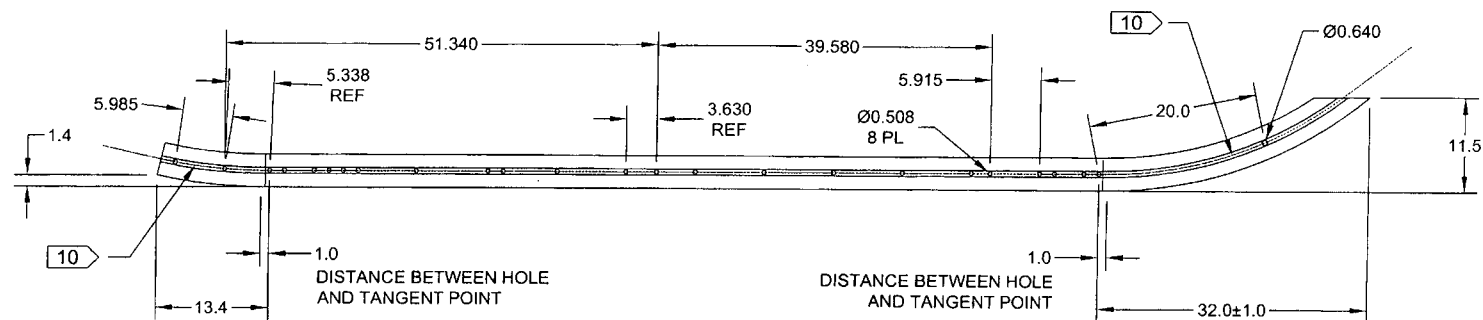
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

DEO ATTACHED
RELEASED
2011-08-29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
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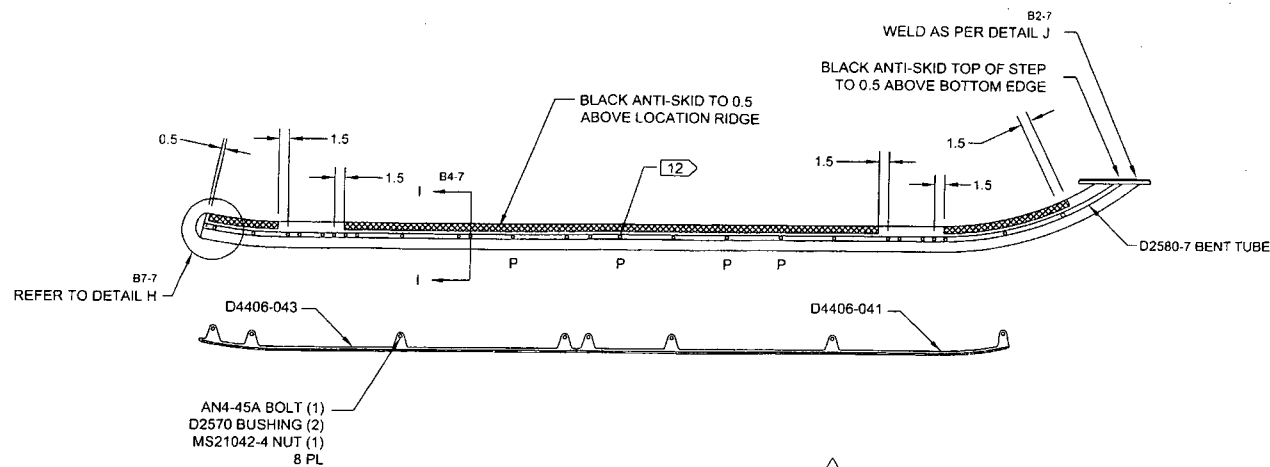
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

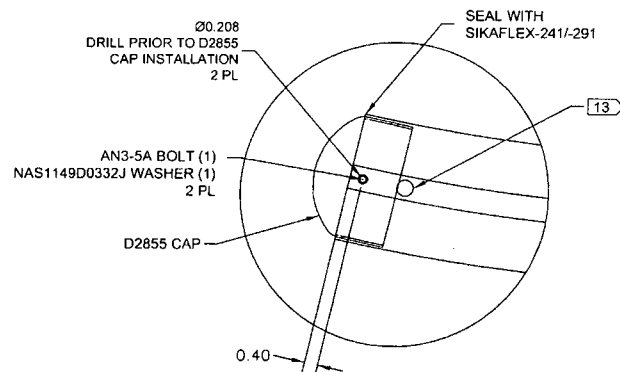
NOTE: Date & initial all entries



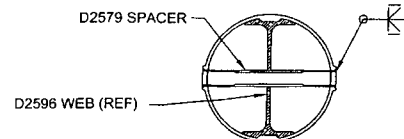
D2580-047 ASSEMBLY DETAIL E

DEO ATTACHED
RELEASED
2011-08-29

DETAIL H C6-7
SCALE 5X



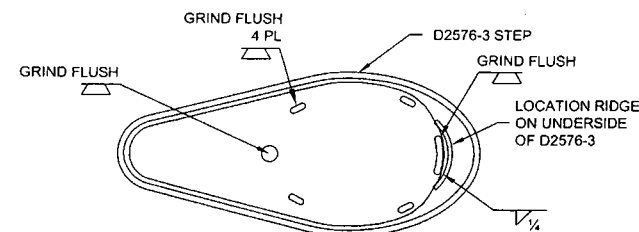
SECTION I-I 05-7
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (25 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL J D3-7
SCALE 5X



DESIGN	4	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	15	D2580	SHEET 6 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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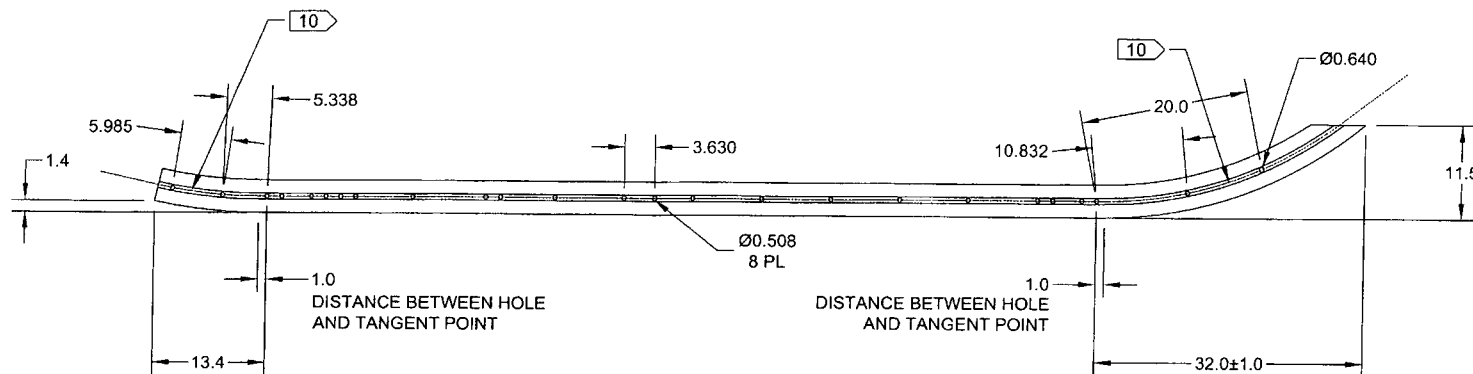
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)



DEO ATTACHED

RELEASED
2011-08-29
AW

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

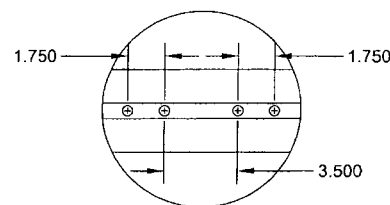
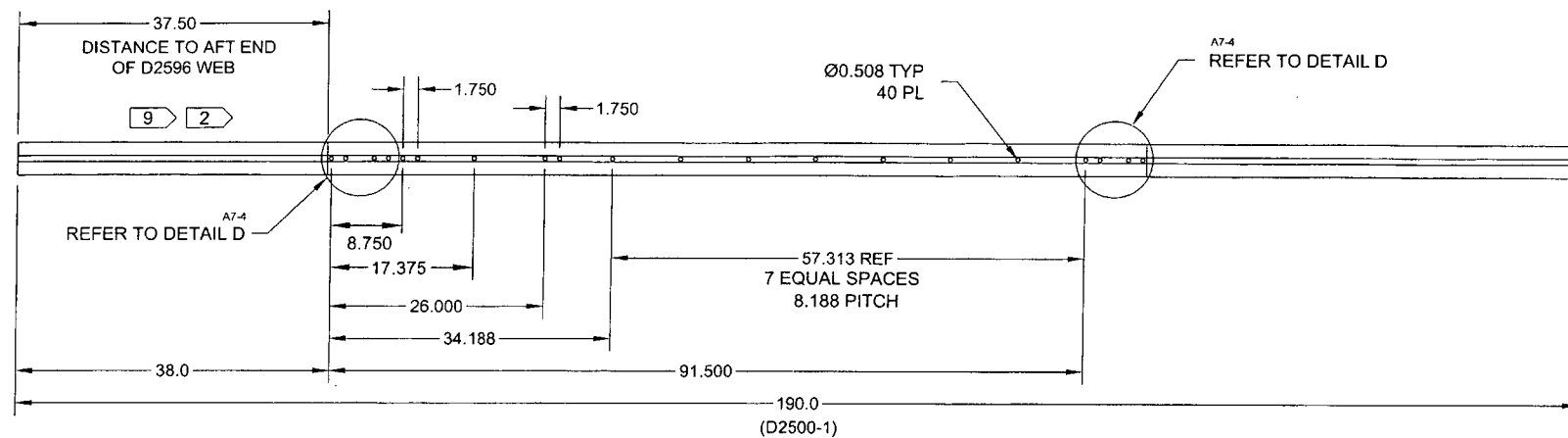
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80691



DETAIL D
SCALE 5X
D3-4
C7-4

D2580-101 TUBE

DEO ATTACHED
RELEASED
2011-08-29

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 8 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	#	205 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D2580-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>ER</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 11.12.13	DATE 11.12.13	DATE 11.12.13	DATE 11.12.13	DATE 11.12.13		

PURPOSE:

CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

gaog

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045	-047		
20	24	25	D2579	CROSS BOLT SPACER

IS

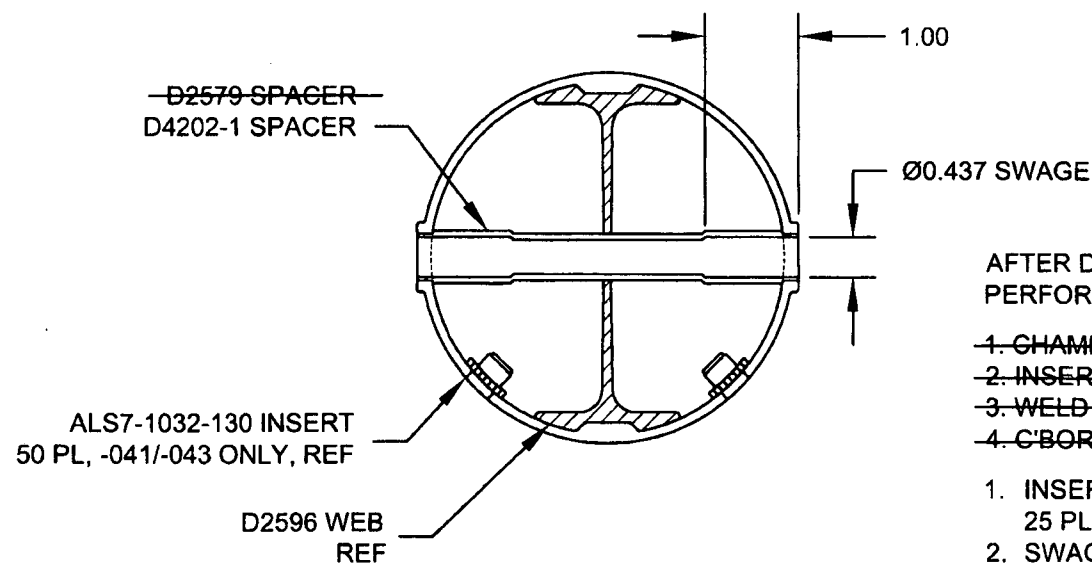
	4		* D2579	CROSS BOLT SPACER
20	20	25	D4202-1	SPACER

*** FOR -045 SKIDTUBE ONLY:**

WELD 4X D2579 SPACERS PER DWG
IN LOCATIONS MARKED "NO C'BORE".
REF SHEET 4 OF DWG.

SECTION B-B, SECTION F-F, & SECTION I-I ARE AMENDED AS FOLLOWS
FOR ALL HOLES THAT WERE ORIGINALLY C'BORED:

RELEASED
2011-12-14 *[Signature]*



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

- ~~1. CHAMFER HOLE 0.050 X 45°~~
- ~~2. INSERT D2579 SPACER (20 PLACES)~~
- ~~3. WELD INTO PLACE AND GRIND FLUSH~~
- ~~4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP~~

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 20 PL (-045) OR 25 PL (-047)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B, F-F, I-I
NOT TO SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries